

Work Order ID 86259

86259

Page 1

June-25-12 2:25:22 PM

Item ID: D2656-31

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 25/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/25 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2656	Rev D					(B)			
100		0.00							
100	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
1010 .040	1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2- Deburr if necessary								B12-6-XC
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								B12-6-XC
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo					(+e)			S1206127

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. Identify as D2656-31.

(Signature)

SD 12/07/03

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

5/12/03

(Signature)

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320015

1:50

4X4

m/f 12/07/04

m121279

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Process Plan:

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

H ϕ BLD-7-4

170

Identify as per dwg & Stock Location: EP

0.00

170

Packaging

Memo

0.00

Packaging

4x 12-7-5

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

OK 12/7/6

ME 12-07-05

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Picklist Print

June-25-12 2:25:26 PM

Page 1

Work Order ID: 86259

86259

Parent Item: D2656-31

D2656-31

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: D02.10.25Re-formatKJ

IPP Rev:E 06-06-12 Now On Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S20GA

Purchased

No

100

sf

198.0700

0.39

1.642105

2,

M1010S20GA

B12-6-06

1010/1025 SHEET

Location

Loc Qty

Loc Code

MAT019

198.07

111410

26.9

116791

43.17

121780

128

116791

ⓐ

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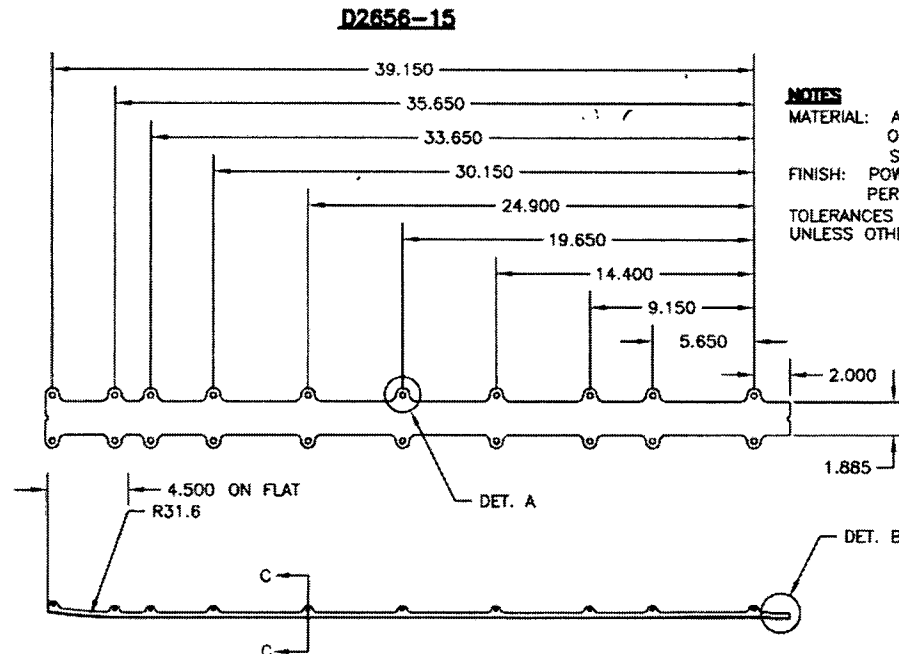
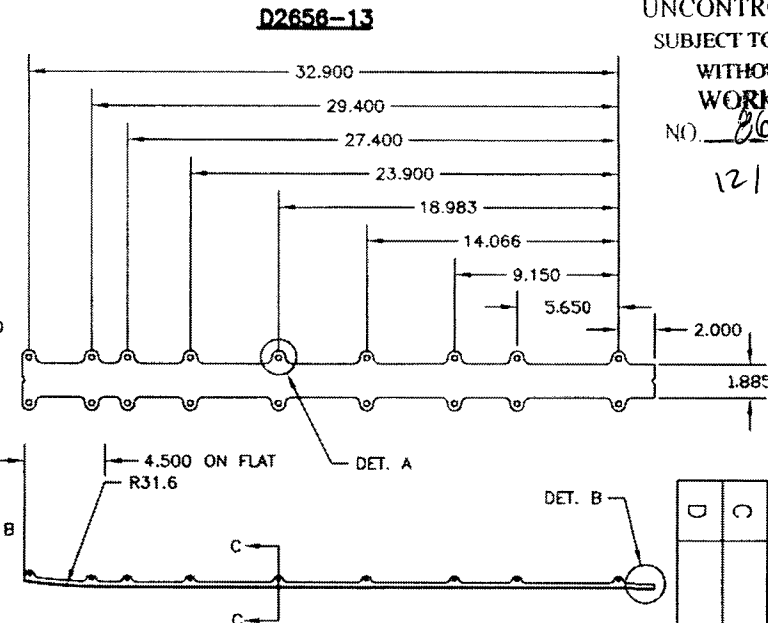
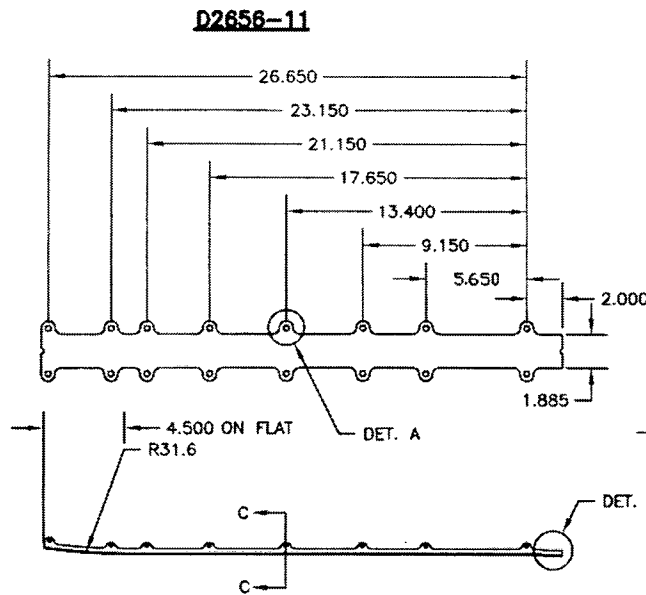
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 80259 MLW
12/06/25

DART



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05-09-06

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DS	CP			
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 4	SCALE
		D2656		1:10
DATE	TITLE	WEARSHOE		
05.08.17				
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

W/O:		WORK ORDER CHANGES					
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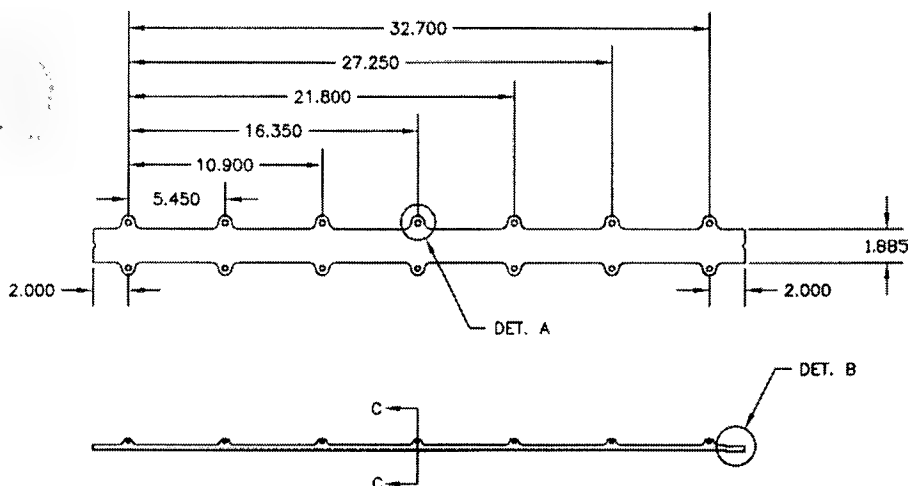
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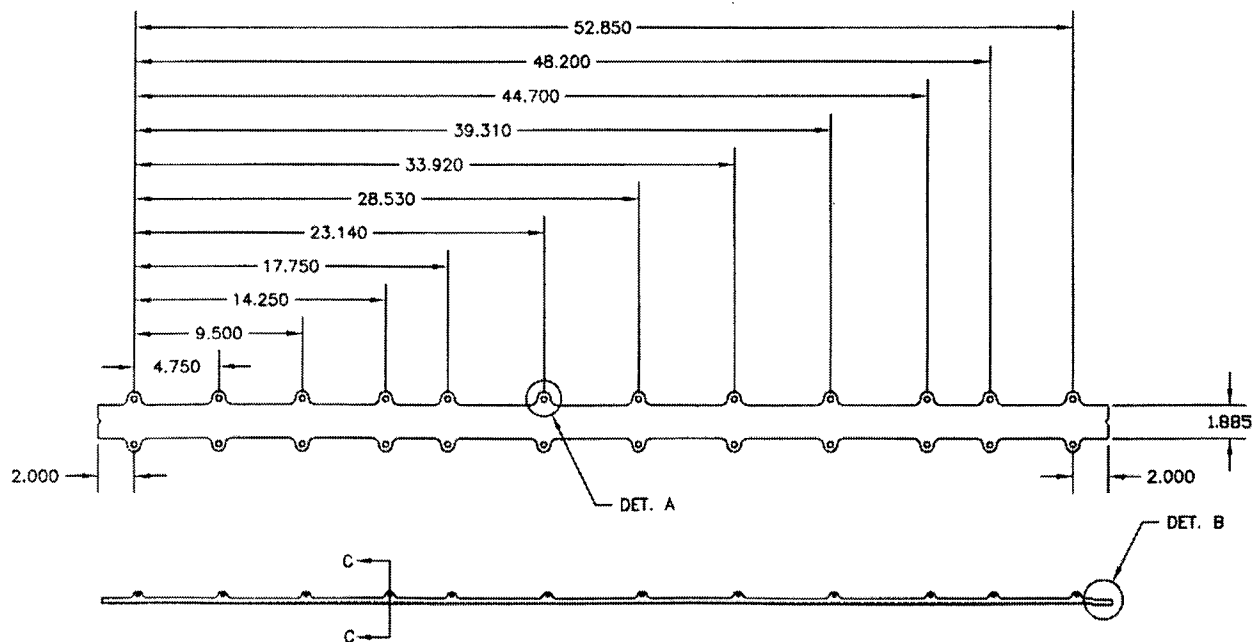


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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

D2656-21



D2656-23



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MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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 FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018
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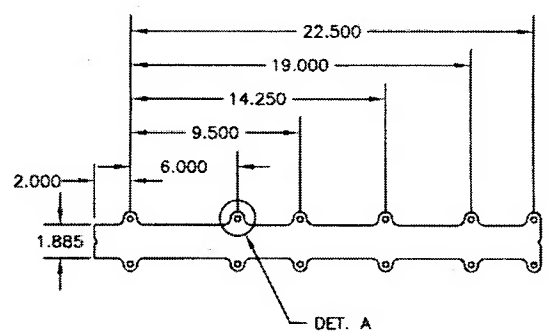
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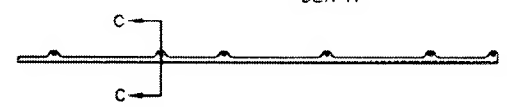
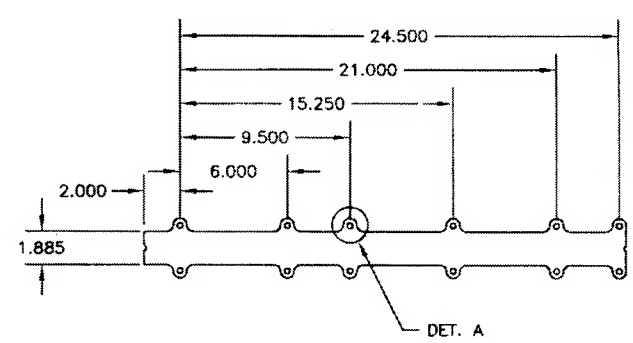


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DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

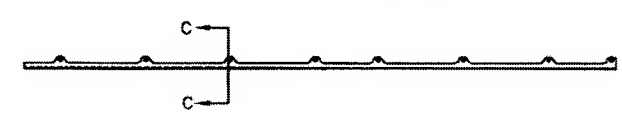
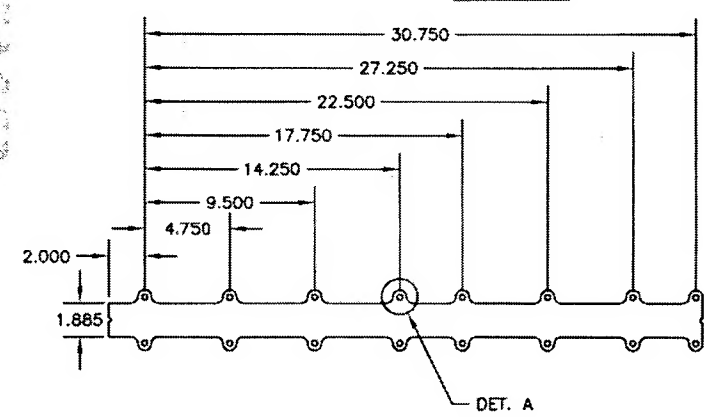
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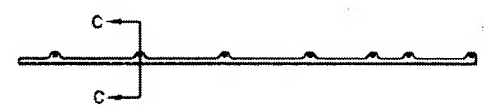
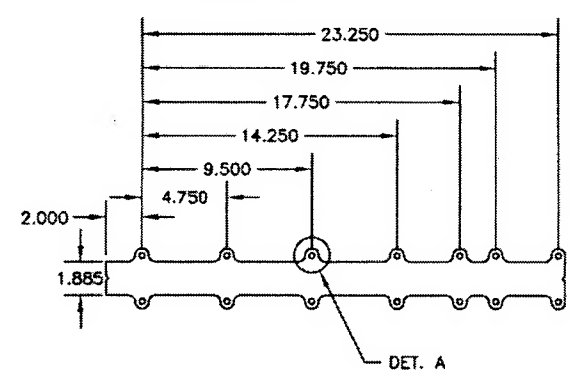
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D2656-37



D2656-35



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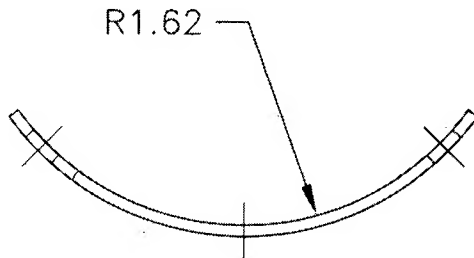
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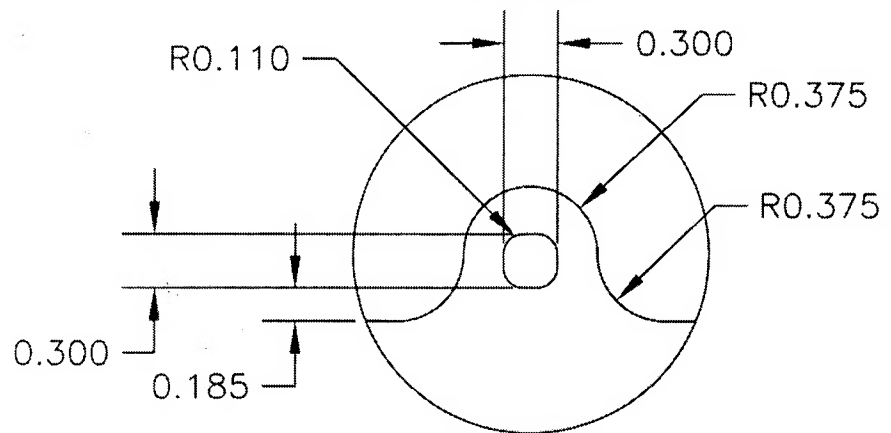
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<i>[Signature]</i>	<i>[Signature]</i>	D2656	SHEET 4 OF 4
DATE	TITLE		SCALE
05.08.17	WEARSHOE		1:10

SECTION C-C

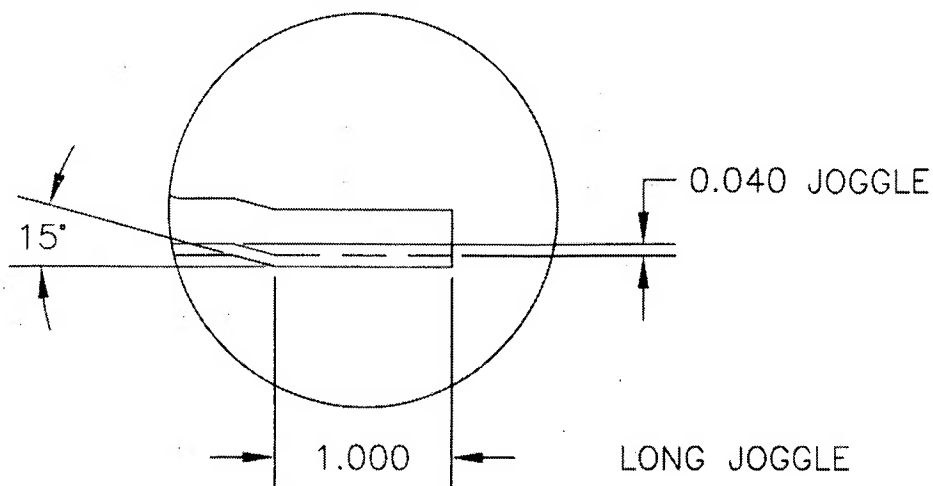


RELEASED
05.09.06

DETAIL A



DETAIL B



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